

303 500

Work Order ID 69887



Page 1

Tuesday, May 24, 2011 10:03:26 AM

Item ID: D3439-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stud

Start Date: 5/24/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-24

Tooling:

Date:

Run Start



QC:

Date: 11-05-24

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3439

B

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

0.00

TURN AS PER FOLIO FA959

FOLIO REV: 11/15

DWG REV: 15

DEBURR

SD 11/15/12

20 11/15/12

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SD 11/15/12

20 11/15/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69887

Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00



QC Memo

0.00

Quality Control

20 11.6.2

20

130 Identify as per dwg & Stock Location: *GA*

0.00



Packaging Memo

0.00

Packaging

EP 11/06/07 (20)

140 QC21- Final Inspection - Work Order Release

0.00



QC Memo

0.00

Quality Control

*11/08/07**11-06-7
20*

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Picklist Print

Tuesday, May 24, 2011 10:03:32 AM

Page 1

Work Order ID: 69887

Parent Item: D3439-3

Parent Item Name: Stud




Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 10.09.08 new issue verf:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.500  303 Round Bar 0.500"		Purchased	No			100	f	48.5000	0.113	2.378947			



11/6/12

Location

Loc Qty

Loc Code

MAT028

48.5

117143

48.5

2.378947

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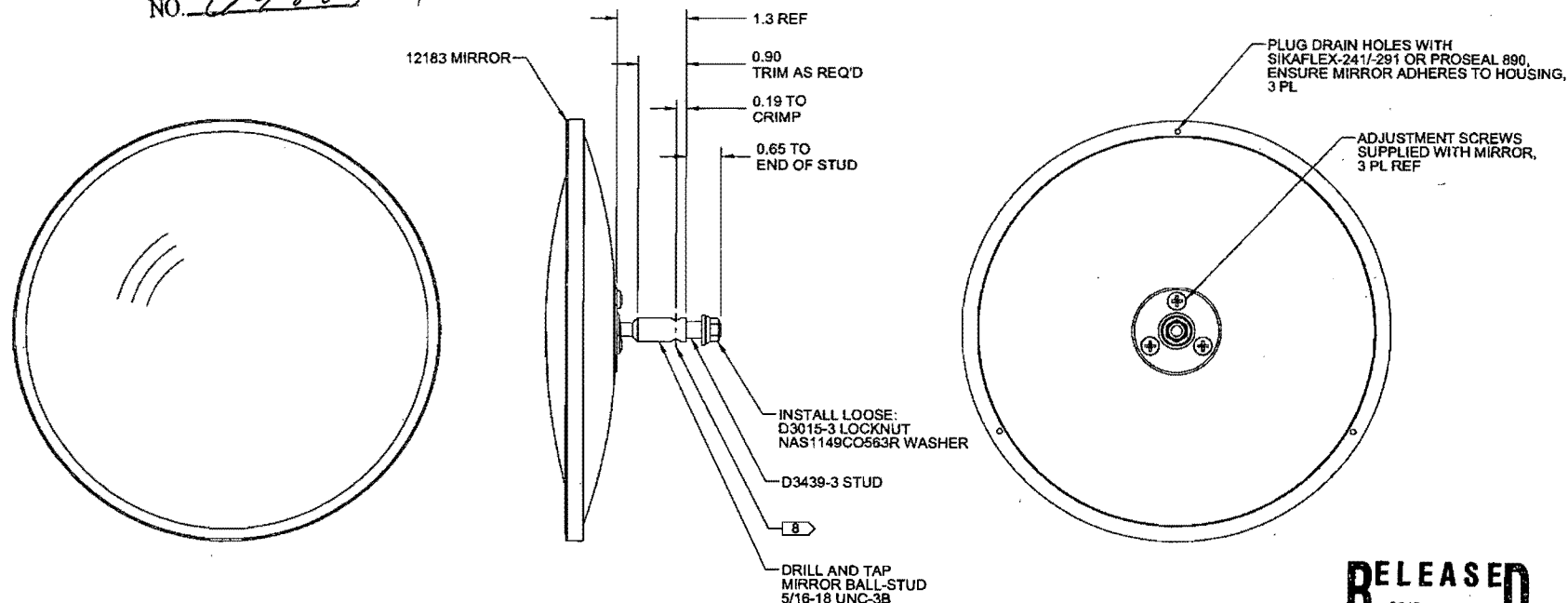
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09887 *11-05-24*

ITEM	QTY -101	P/N	DESCRIPTION
1	X	D3439-101	MIRROR ASSEMBLY, 8"
2	1	12183	MIRROR 8" (GROTE)
3	1	D3015-3	LOCKNUT
4	1	D3439-3	STUD
5	1	NAS1149CO563R	WASHER (OR AN960JD516)



D3439-101 MIRROR ASSEMBLY

NOTES:

- 1) MATERIAL: MIRROR= 8" ROUND CONVEX MIRROR W/ STAINLESS STEEL CASE
CENTER-MOUNT BALL-STUD W/ 1/4-20 X 1" DEEP FEMALE THREAD
GROTE INDUSTRIES, 2600 LANIER DRIVE, MADISON, INDIANA 47250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3439-101" USING REMOVEABLE TAG
- 7) WEIGHT: 1.18 lbs
- 8) TO INSTALL D3439-3 STUD:
 - APPLY LOCKTITE 262 TO THREADS BEING INSTALLED INTO MIRROR BALL-STUD
 - THREAD D3439-3 STUD INTO MIRROR BALL-STUD
 - CRIMP MIRROR BALL-STUD ON OPPOSING SIDES, 0.19 FROM END AS ILLUSTRATED USING TOOL DT8317
 - CRIMP TO DEPTH OF 0.015-0.030 USING R0.125

RELEASED
2010-09-07

B	REDRAW, ADD -3 (WAS PURCHASED/TRIMMED BOLT), RMV LPS	CP	10.07.20
A	NEW ISSUE	CP	05.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.20		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3439	REV. B
TITLE MIRROR ASSEMBLY	SCALE NTS
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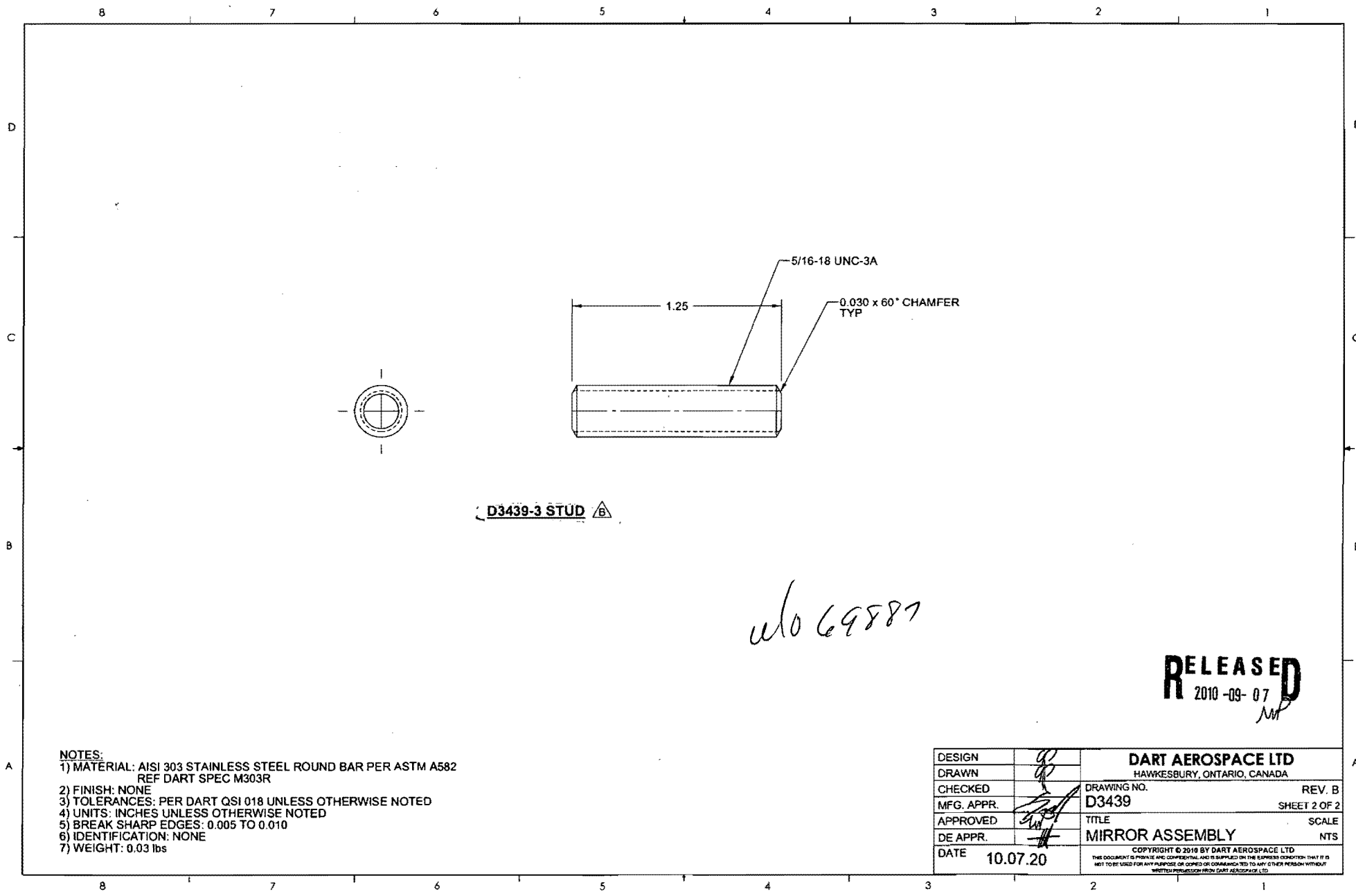
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D3439-3 STUD 

ULO 69887

RELEASED
2010-09-07
MP

- NOTES:
1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010
6) IDENTIFICATION: NONE
7) WEIGHT: 0.03 lbs

DESIGN	<i>MP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>MP</i>	DRAWING NO. D3439	REV. B
CHECKED	<i>MP</i>	SHEET 2 OF 2	
MFG. APPR.	<i>MP</i>	TITLE	SCALE
APPROVED	<i>MP</i>	MIRROR ASSEMBLY	NTS
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DATE	10.07.20		

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